

Split

Work Order ID 79036-2

79036

Page 1

January-18-12 3:52:59 PM

Item ID: D3393-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Battery Lock Assembly

Start Date: 18/01/2012 Start Qty: ~~10.00~~ 8

10

Cust Item ID:

Required Date: 01/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: *MA 1.2*

Date: *12/03/12* Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3393

Rev A

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest 2-Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-53-Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten

⑧

FF 12-02-29

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

Tack Weld lock shaft to flat cam of a Max 1/8" Long Qty Part Number Description Batch A/RN/A SS Rod *M114508*

A 12-2-29 *(X8)*

120

QC9-Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

Pl 12-02-29

8x8

Work Order ID 79036

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Page 2

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Item ID: D3393-041

Accept

N9000040100

Setup Start

NS1

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Stop

NS2

Item Name: Battery Lock Assembly

Start Date: 18/01/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 01/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

Small Fab

Small Fab

Memo:

0.00

Small Fab

Apply Crazy Glue to cap and press into Body 9567K21

Batch: H120590

(8) FF 12-02-29

140

0.00

140

QC

QC'S- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

SP 12/03/01

(X8)

150

0.00

150

Packaging

Identify as per dwg & Stock Location

Memo

0.00

Packaging

SP 493

(8X) SP 12-03-01

Work Order ID 79036

79036

Page 3

January-18-12 3:52:59 PM

Item ID: D3393-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Battery Lock Assembly

Start Date: 18/01/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 01/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/3/11
MF
12-03-11

Picklist Print

January-18-12 3:53:03 PM

Page 1

Work Order ID: 79036

79036

Parent Item: D3393-041

D3393-041

Parent Item Name: Battery Lock Assembly

Start Date: 18/01/2012

Required Date: 01/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 05-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
5/16WC*		Purchased	No			100	Each	3,590.000	2	20	⑧	FF 12-02-29	
5/16WC									**				

SS Flat Washer 5/16 FW516S1

Location	Loc Qty	Loc Code
ST377	3290	
119343	590	
120262	2700	
ST522	300	
120208	300	

9567K21

Purchased No

100 Each 27.0000 2 20

9567K21

Polyethylene Cap

**

⑧ FF 12-02-29

Location	Loc Qty	Loc Code
ST380	27	
110822	27	

D2728-7

Manufactured No

100 Each 0.0000 0 0

D2728-7

Dart Logo label

D3373-1

Manufactured No

100 Each 69.0000 1 10

D3373-1

Cam Lock

**

**

⑧ FF 12-02-29

⑧ FF 12-02-29

Location	Loc Qty	Loc Code
ST039	69	
58463	2	
74862	19	
75666	48	

pe 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-18-12 3:53:03 PM

Page 2

Work Order ID: 79036

Parent Item: D3393-041

Parent Item Name: Battery Lock Assembly

79036

D3393-041

Start Date: 18/01/2012

Required Date: 01/02/2012

Start Qty: 10.00

Required Qty: 10.00

D3393-1

Manufactured No

D3393-1

Battery Lock Casing

75222

100 Each

3.0000 1 10

**

⑧ FF 12-02-29

Location

Loc Qty

Loc Code

st493

3

62953

3

D3393-3

Manufactured No

D3393-3

Cam Lock Shaft

B77090A

140 Each

0.0000 1 10

**

⑧ FF 12-02-29

28

January-18-12 3:53:03 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

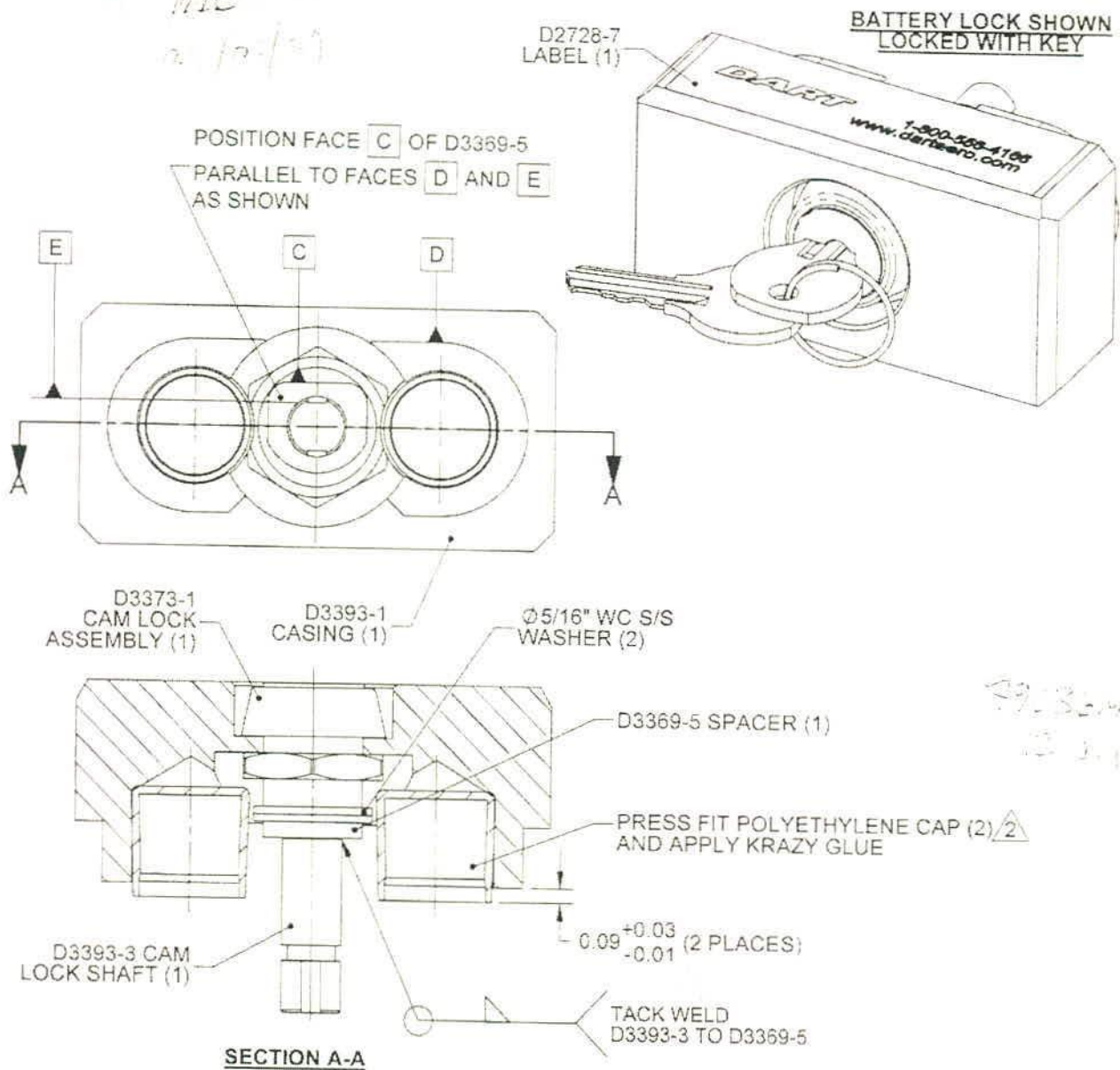
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3393	REV. A
DATE 05.02.08		TITLE BATTERY LOCK	SHEET 1 OF 3 SCALE 1:1
A	05.02.08	NEW ISSUE	



D3393-041 BATTERY LOCK ASSEMBLY

NOTES:

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

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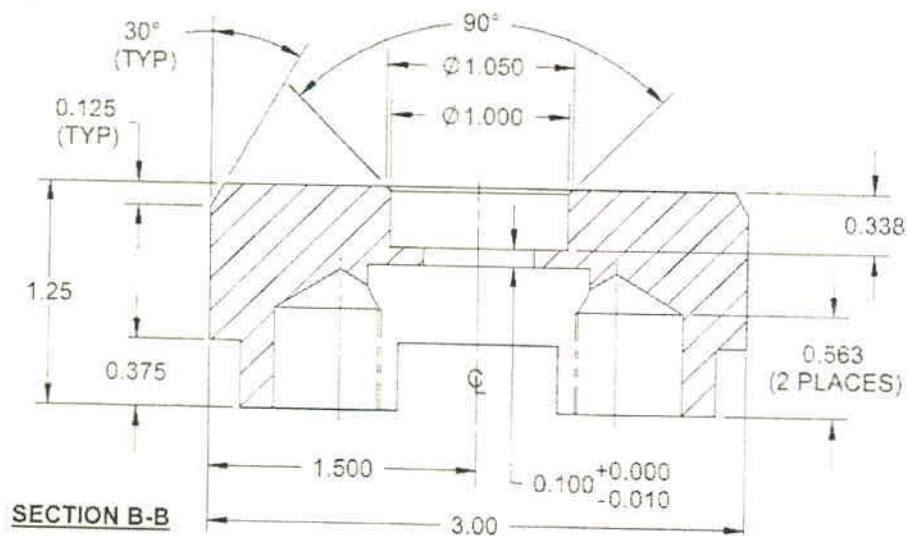
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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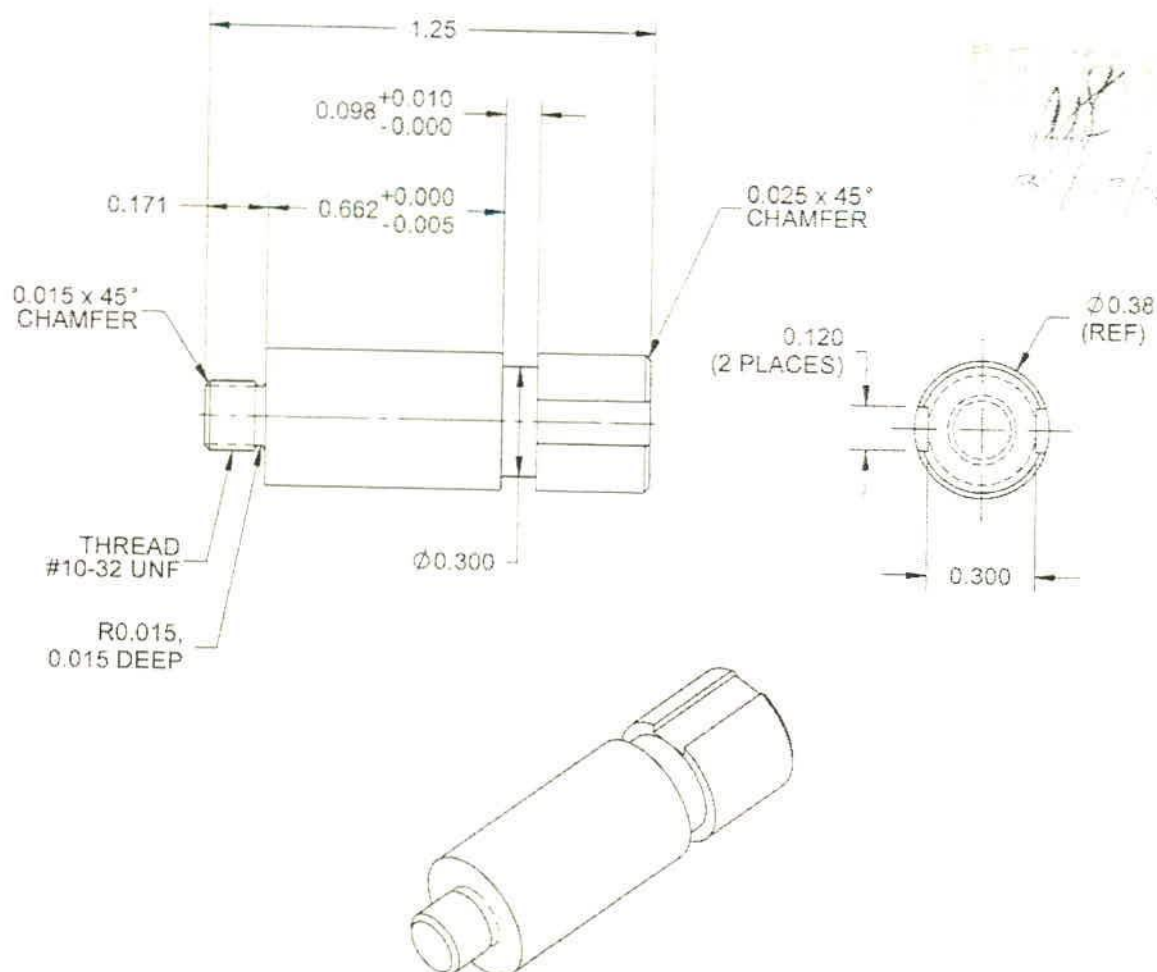
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



49036

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3393	REV. A
DATE 05.02.09		TITLE BATTERY LOCK	SHEET 3 OF 3
			SCALE 2:1



D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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